

Work Order ID 86089

June-20-12 12:59:00 PM

86089

Page 1

Item ID: D3016-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Frame Assembly

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	RevA / DEO A-1								
100	Weld per dwg A/R 4130 rod Batch <u>M1188X</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut all tubes as per Dwg D3016								
	2-Deburr								
	3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597								
	4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041								
	5- Assemble brackets and gusset per dwg and weld								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

12-7-12

BE 12/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 20/06/2012 Start Qty: 1.00 ***1***
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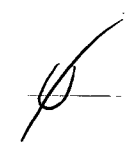
Cust Item ID:
Customer:


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	Install paint screws on fitting ends START TIME: 11:00 OVEN TEMPERATURE: 320°F FINISH TIME: 11:30								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

IX  M.L.
12/07/10

I  BL 12-710.

W/O:		WORK ORDER CHANGES					
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Required Date: 04/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

Identify as per dwg & Stock Location: G-A

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/17/18

MLJ 12/07/10

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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:59:03 PM

Page 1

Work Order ID: 86089

86089

Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049		Purchased	No			100	f	105.9200	4.3	4.526316			
										**		12-7-5	

M4130NT0 750W 049

4130 RD Tube .750 x.049W

Location	Loc Qty	Loc Code
MAT033	105.92	
120350	65.61	
121025	40.31	

M4130NT0.500W.049 Purchased No

M4130NT0 500W 049

4130 RD Tube .500 x.049W

Location	Loc Qty	Loc Code
MAT032	43.48	
121025	43.48	

M4130NT1.000W.120 Purchased No

M4130NT1 000W 120

4130 RD Tube 1.00 x .120wall

Location	Loc Qty	Loc Code
MAT033	64.53	
117656	20.27	
117973	44.26	

D3016-17 Manufactured No

D3016-17

Gusset

Location	Loc Qty	Loc Code
WA021	22	
70872	12	
70909	10	

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Picklist Print

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Page 2

Work Order ID: 86089

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

86089

D3016-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3016-13

Manufactured No

100

Each

6.0000

2

2

D3016-13

Bracket

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

6

76567

6

D3016-15

Manufactured No

100

Each

8.0000

2

2

D3016-15

Gusset

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA

8

77579

8

D3020-1

Manufactured No

100

Each

8.0000

4

4

D3020-1

Fitting

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

8

36713

1

76579

7

85978

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86085* *M-5*
12/30/20

DEO ATTACHED

RELEASED
01.05.30 *4P*

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

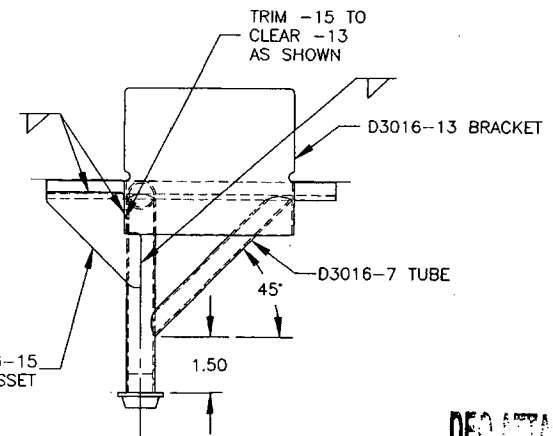
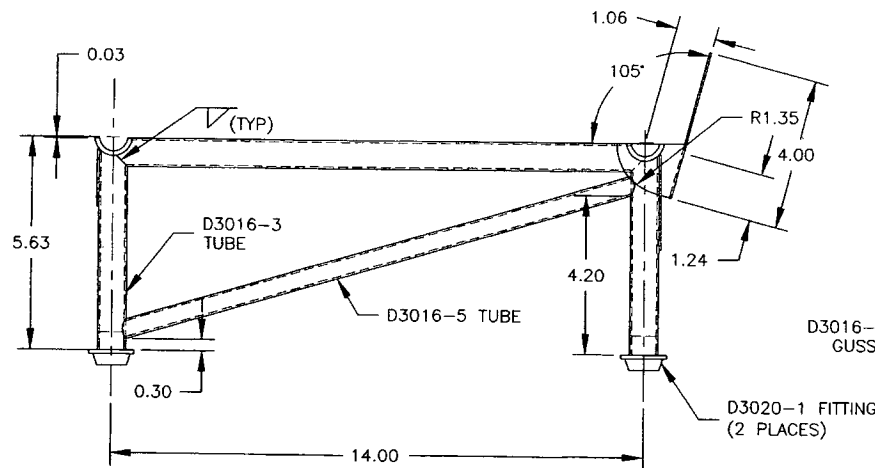
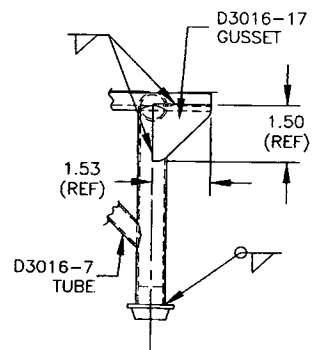
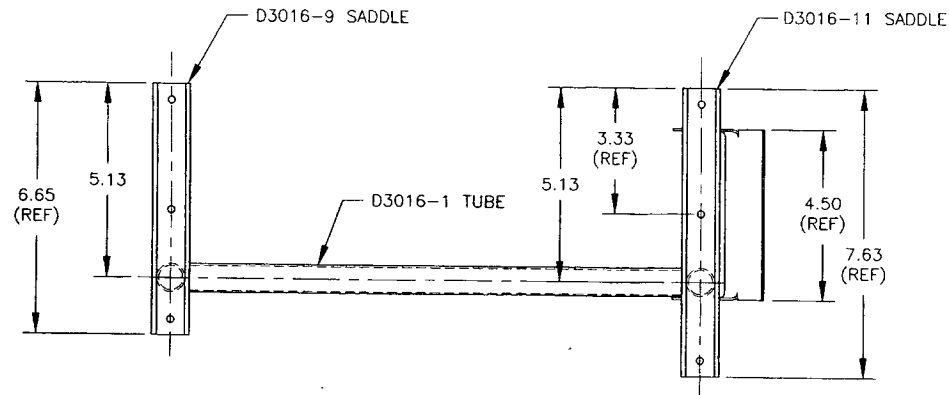
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D3016-Q41 SEAT FRAME ASSEMBLY

86089



DETACHED

RELEASED
01.05.30

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 2 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY		SCALE 1:3	

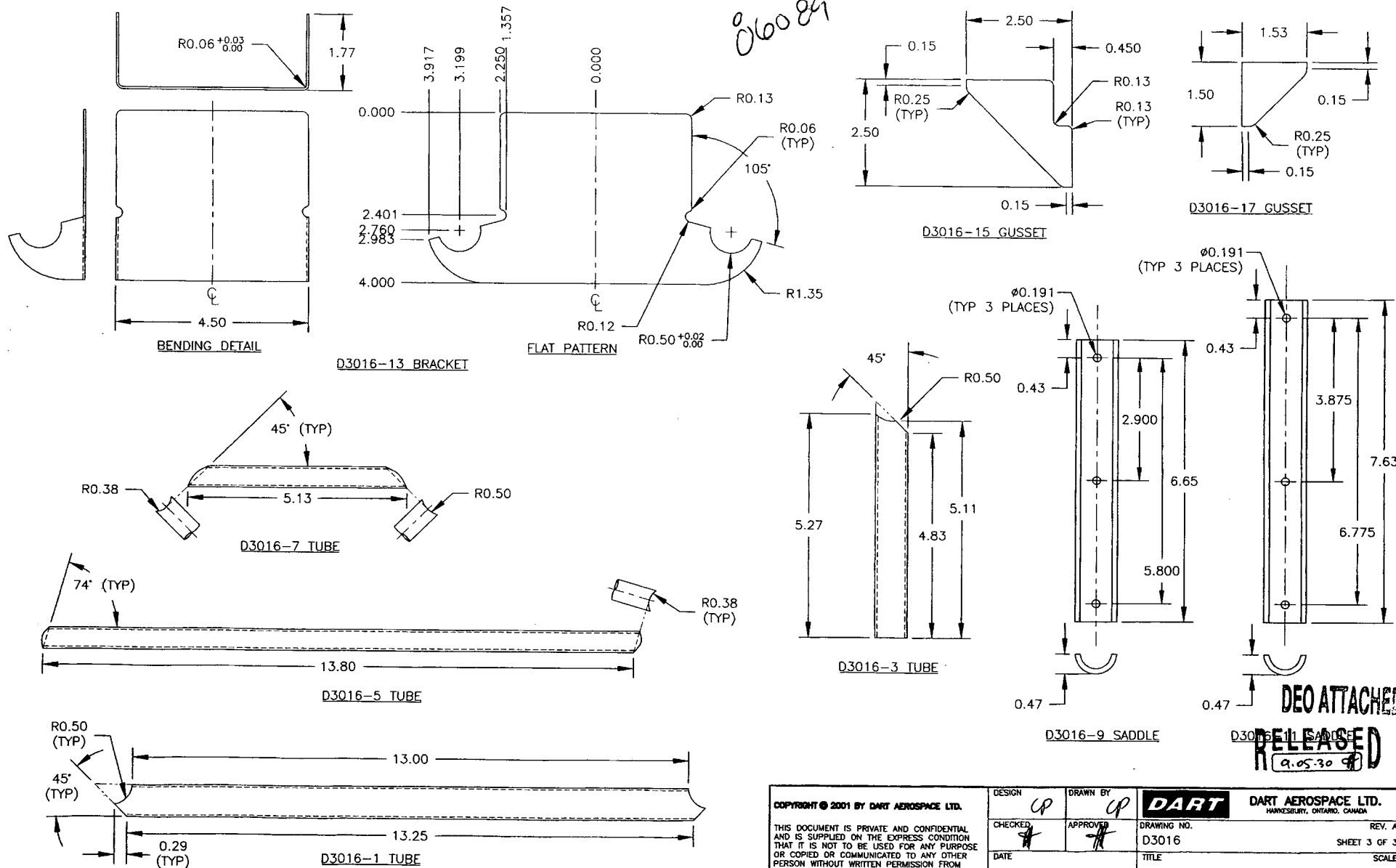
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DATE		01.05.18		DRAWING NO.	REV. A
				D3016	SHEET 3 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:2

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MP</i>	DE APPR. <i>TH</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

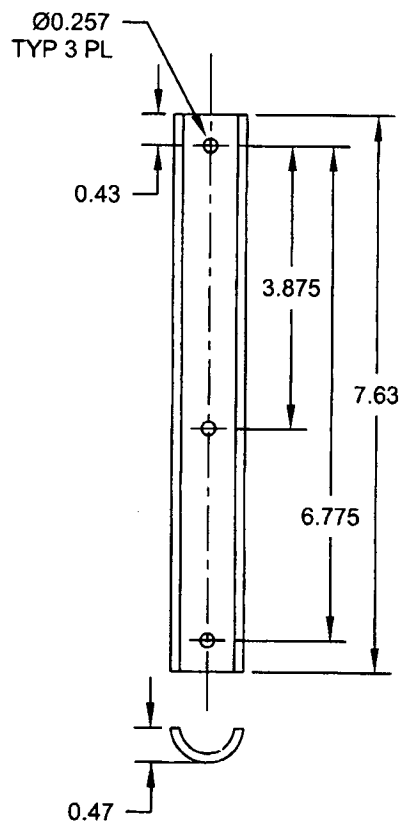
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

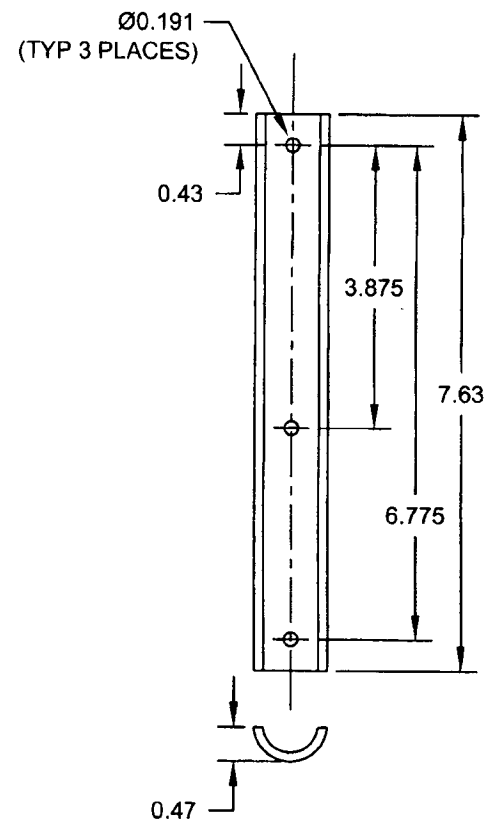
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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